

Date: Wednesday, 09/04/2008 9:18:31 AM
User: Julie Lecocq

Split

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-350 AFT CANOPY		
Job Number	38505 <u>2</u>			Part Number	: D36561		
Estimate Number	13098			Drawing Number	: D3656 REV A		
P.O. Number	:			Project Number	: 00204		
This Issue	09/04/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	NC			Material	:		
First Issue	11	Type	THERMOFORMING	Due Date	30/04/2008	Qty:	2
Previous Run	37665			Um:	Each		
Written By	:						
Checked & Approved By	<u>JB 08.4.09</u>						
Comment	Est. Rev. A 07/12/13 DL verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
Comment: Qty.: 23.0000 sf(s)/Unit Total : 46.0000 sf(s) GE PLASTICS LEXAN SHEET batch: <u>H105494</u>		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING 1) Cut Blanks to fit frame size		
3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D3656-1and Folio FTA 015 using tool DT 8986		
Dwg. Rev. <u>A</u> Folio Rev. <u>A</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE Visually inspect for proper formation of each part		



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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



08/04/08
XJ

Comment: SECOND CHECK

6.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



08/04/08
XJ

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08/04/08
XJ

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

MS 39357 08/04/08 (1)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/08
XJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 8/05/08



DART AEROSPACE LTD	WORK ORDER:	38505
Description: PANEL 350 AFT CANOPY	Part Number:	D3656-1
Inspection Dwg: D3656 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

(Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
Tight, even radius throughout part	
Acceptable shape definition	
Acceptable texture retention	
Free of visual flaws (bumps, cracks, voids, etc.)	

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3X56, Rev. A and record below.

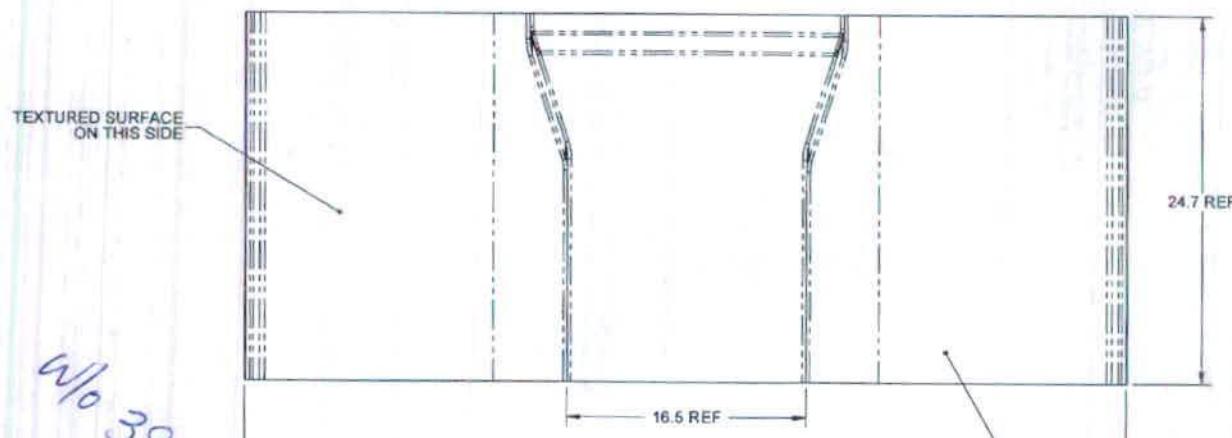
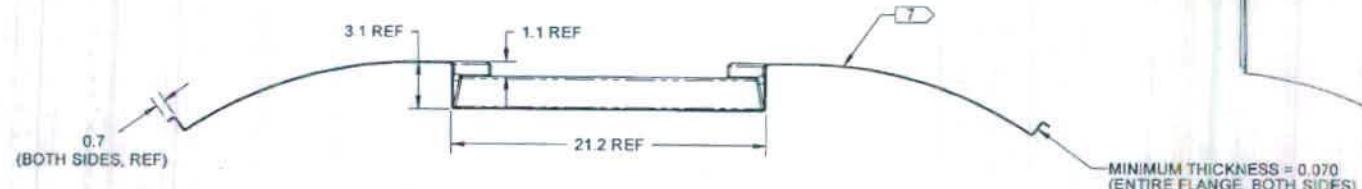
Measured by: Dh
Date: 08-04-10

Audited by: _____
Date: 10-01-24

Prototype Approval: W
Date: 26.04.10

Rev	Date	Change	Revised by	Approved
		New Issue		





D3656-1 PANEL

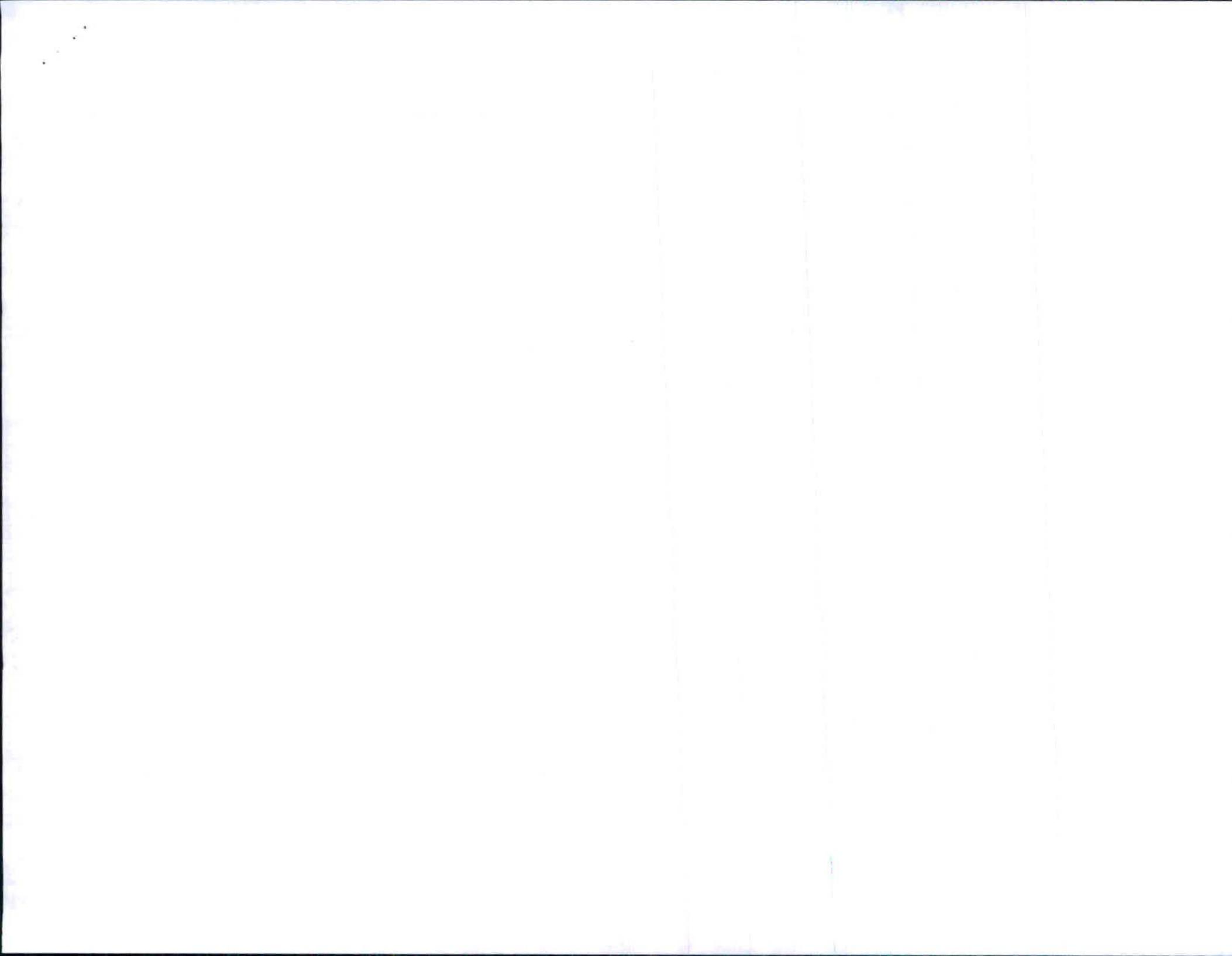
- NOTES:
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
 - 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER MOLD DT8986
 - 3) FINISH: NONE
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
 - 8) WEIGHT: 6.6 lbs
 - 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

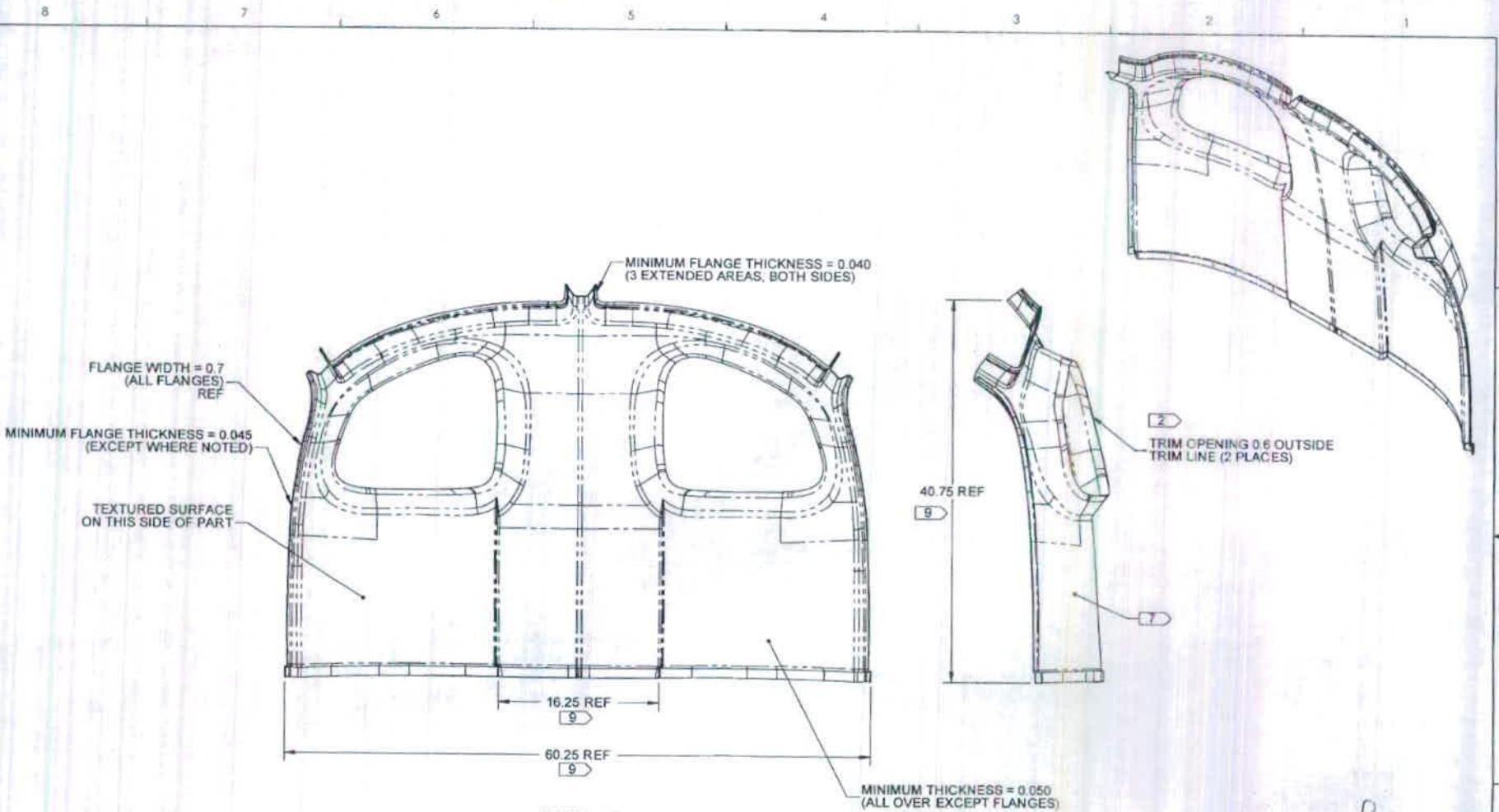
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	CE		
DRAWN	CE		
CHECKED	AF		
MFG. APPR.	HP		
APPROVED	MP		
DE APPR.	HT		
DATE	08.03.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3656 SHEET 1 OF 2
TITLE PANEL SCALE NTS

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NOTES

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022
TRIM PER MOLD DT8987 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH PIN AND BIN ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	<i>EE</i>	DART AEROSPACE LTD
DRAWN	<i>EE</i>	HAWKSBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	<i>WJ</i>	REV. A
APPROVED	<i>JW</i>	D3656
DE APPR.	<i>JW</i>	SHEET 2 OF 2
DATE	08.03.03	TITLE
		SCALE
		NTS

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